

[Title of the Document] Claims

[Claim 1] A fabric for clothing at least partly comprising cellulose mixed ester fiber with a glass transition point (T_g) of 160°C or more and a strength of 1.3 to 4 cN/dtex.

[Claim 2] A fabric for clothing according to Claim 1 wherein the initial tensile modulus of said cellulose mixed ester fiber is in the range of 30 to 100 cN/dtex.

[Claim 3] A fabric for clothing according to Claim 1 wherein the CV in single yarn fineness of said cellulose mixed ester fiber is 10% or less.

[Claim 4] A fabric for clothing according to Claim 1 wherein the average single fiber diameter of said cellulose mixed ester fiber is in the range of 5 to 50 μm .

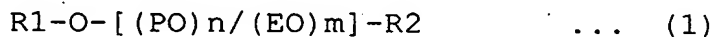
[Claim 5] A fabric for clothing according to Claim 1 wherein the plasticizer in said cellulose mixed ester fiber accounts for 0 to 1.0wt% of the weight of said cellulose mixed ester fiber.

[Claim 6] A fabric for clothing according to Claim 1 wherein the average single fiber diameter of said cellulose mixed ester fiber is in the range of 10 to 50 μm .

[Claim 7] A fabric for clothing according to Claim 1 wherein the total molecular weight of the acyl groups per glucose unit in said cellulose mixed ester is in the range of 120 to 140 and the degree of substitution is in the range of 2.6 to 2.8.

[Claim 8] A production method of a fabric for clothing at least partly comprising cellulose mixed ester fiber, wherein a composition at least consisting of 70 to 95wt% of said cellulose mixed ester and 5 to 20wt% of a water-soluble plasticizer is subjected to melt spinning to produce a fiber of 5 to 50 μm , and said plasticizer is eluted from said fiber by aqueous treatment performed before and/or after a fabric is produced from said fiber.

[Claim 9] A production method of a fabric for clothing according to Claim 8 wherein said water-soluble plasticizer is at least one selected from the following: polyethylene glycol, polypropylene glycol, poly(ethylene-propylene) glycol, and end-capped polymers produced from them, as represented by the general formula (1) described below.



(In the formula, R1 and R2 represent the same group or different groups that may be H, alkyl, or acyl. Here, n and m represent an integer of 0 or more and 100 or less, and meet the following equation: $4 \leq n+m \leq 100$, while / indicates a random- or a block-copolymerized structure, but the structure is a homopolymer when either n or m is 0. Further, E represents CH_2-CH_2 and P represents $CHCH_3-CH_2$.)

[Claim 10] A production method of a fabric for clothing at least partly comprising a cellulose mixed ester fiber according to Claim 8, wherein the glass transition point, T_g , of said cellulose mixed ester fiber after removal of said plasticizer is higher by $60^\circ C$ or more than before the plasticizer removal.

[Claim 11] A production method of a fabric for clothing according to Claim 8, wherein the strength of said cellulose mixed ester fiber after removal of said plasticizer is larger by 0.2 cN/dtex or more than before the plasticizer removal.

[Claim 12] A production method of a fabric for clothing according to Claim 9, wherein 70% or more of the plasticizer is removed from the fiber by performing aqueous treatment for 5 minutes or less.

[Claim 13] A production method of a fabric for clothing according to Claim 9, wherein said plasticizer is removed with an aqueous solution free of scouring agents, followed by treatment with a solution containing a scouring agent.

[Claim 14] A production method of a fabric for clothing according

to Claim 9, wherein a fabric is produced from said fiber, followed by said aqueous treatment to remove said plasticizer.

[Claim 15] A production method of a fabric for clothing according to Claim 8, wherein the fabric produced is equivalent to said fabric for clothing according to claim 1.